

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014811**Date Inspected:** 11-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 7DW+7EW deck plate weld splice and temp attachments and BK001-035 and 036 cantilever members. The weld designations reviewed are as follows:

Bike Path Cantilevers

1. BK001-035-007, 009, 006
2. BK001-036-001, 006, 007, 005
3. BK001-035-053, 049
4. BK001-036-054, 048

7DW

1. OBW7A-008 and temp attachments

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9AW+9BW

This Quality Assurance (QA) Inspector witnessed final tension verification on clips to T Stiffeners located at the bottom plate and side plate (Panel Point 72 ~ 76). Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M16 x 40 RC Set# DHGM160001 and final torque required was 210 N-m.

Manual Torque wrench was been used with Sr. No. 0900001. Please refer the pictures for more comprehensive detail.

9AE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 014 located at SEG053A bike path side of segment. Welder is identified as Mr. Wang Zhong Hua (053753). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR1617 procedure.

Y Location of repairs areas by above noted welder (053753) is located at 80, 290, 730 and 1120mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 043 located at SEG050A cross beam side of segment. Welder is identified as Mr. Jiang Zhen (068917). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR1612 procedure.

Y Location of repairs areas by above noted welder (068917) is located at 170, 210, 1300, 1320 and 975mm.

9AW+9BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 005 located at OBW9 cross beam side of segment. Welder is identified as Mr. Li Zaijun (037996). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

8CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 021 located at OBW8A counter weight side segment. Welder is identified as Mr. Dong Haitao (067183). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 021 located at OBW8A counter weight side segment. Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

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Shield Metal Arc Welding (SMAW) welding was performed on weld joint 021 located at OBW8A counter weight side segment. Welder is identified as Mr. Feng Changdou (067572). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

8BW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 002 and 006 located at CA050 cross beam side segment. Welder is identified as Mr. Xu Zichuan (205098). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-1 and CWR1614 procedure.

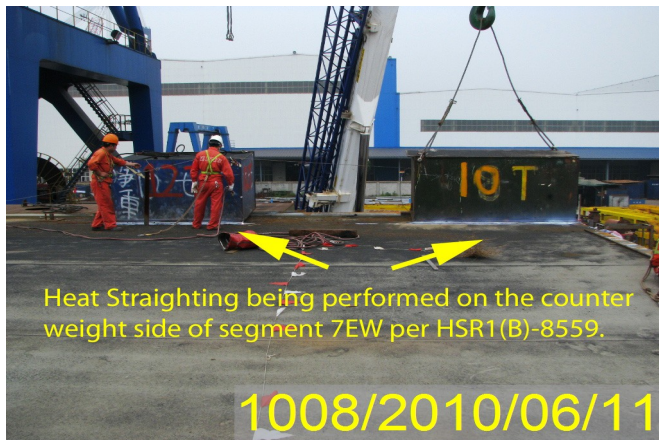
Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions at Tail Assembly Yard. Locations and description of work are as followed:

7EW

1. Heat straightening was performed on deck plate weld joint SEG041*-010 located on the counter weight side of segment per HSR1 (B)-8559.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

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Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
